

Work Order ID 58696

Monday, May 17, 2010 10:08:51 AM



Page 1

Item ID: D4034-041

Accept



Setup Start



Revision ID:

Item Name: Aft Upper Rib Assembly

Stop



Start Date: 5/17/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: MC

Date: 10-5-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4034	A								

100 Weld per dwg A/R S.S. rod Batch: M111679 0.00



Large Fab

Memo

0.00

10-05-17

3 8

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564
 2- Weld bushing in rib and grind weld flush as per dwg

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

③ 10-05-18

Quality Control

120 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

S. w. 18

(x3)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4034-041

Accept



Setup Start



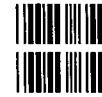
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Customer:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: WA

0.00

SAD
10-05-17

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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Resolution				Disposition: _____	QA: N/C Closed: _____		Date: _____		
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Picklist Print

Monday, May 17, 2010 10:08:50 AM

Page 1

Work Order ID: 58696



Parent Item: D4034-041



Parent Item Name: Aft Upper Rib Assembly

Start Date: 5/17/2010

Required Date: 5/21/2010

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D4034-1		Manufactured	No			100	Each	6.0000	1		<i>10.05.17</i>	
Rib					<i>WA 358405</i>							
					WA			6			<i>3</i>	
					200003			6			<i>B</i>	
D4034-3		Manufactured	No			100	Each	3.0000	1		<i>10.05.17</i>	
Rib					<i>WA 58408</i>							
					WA			3			<i>3</i>	
					58408			3			<i>B</i>	
D4021-7		Manufactured	No			100	Each	2.0000	1		<i>10.05.17</i>	
Hoop					<i>WA 358484</i>							
					WA			2			<i>2</i>	
					58039			1			<i>1</i>	
					58153			1			<i>2</i>	
D4021-9		Manufactured	No			100	Each	22.0000	2		<i>10.05.17</i>	
Bushing					<i>WA 58417</i>							
					WA			4			<i>34</i>	
					56094			4			<i>4</i>	
					58404			18			<i>2</i>	
								2			<i>2</i>	
								16			<i>2</i>	

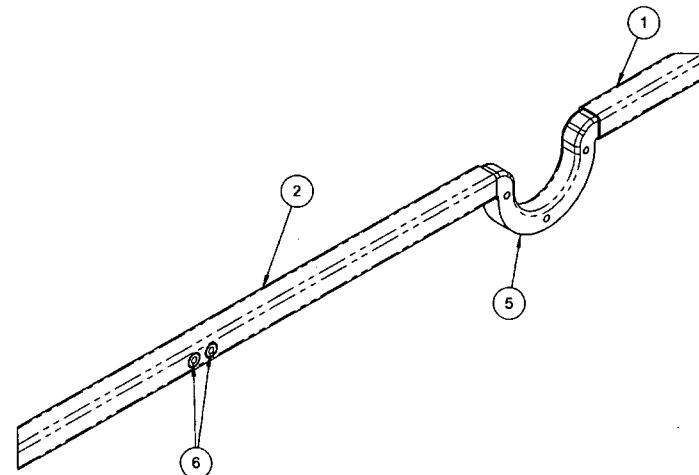
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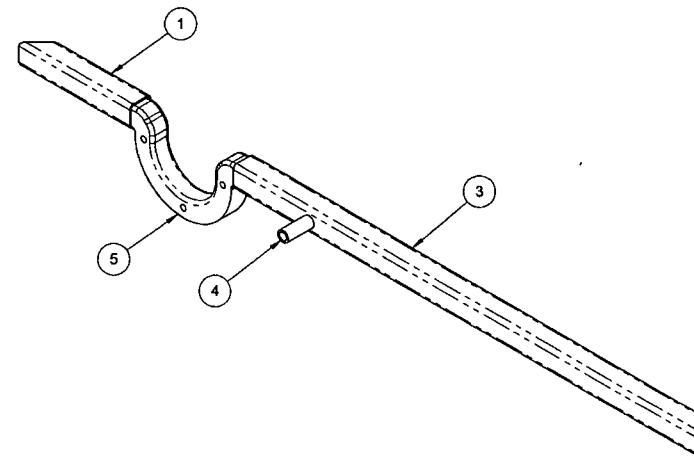
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	2		D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

RELEASED
2010-03-12
MP

#58694

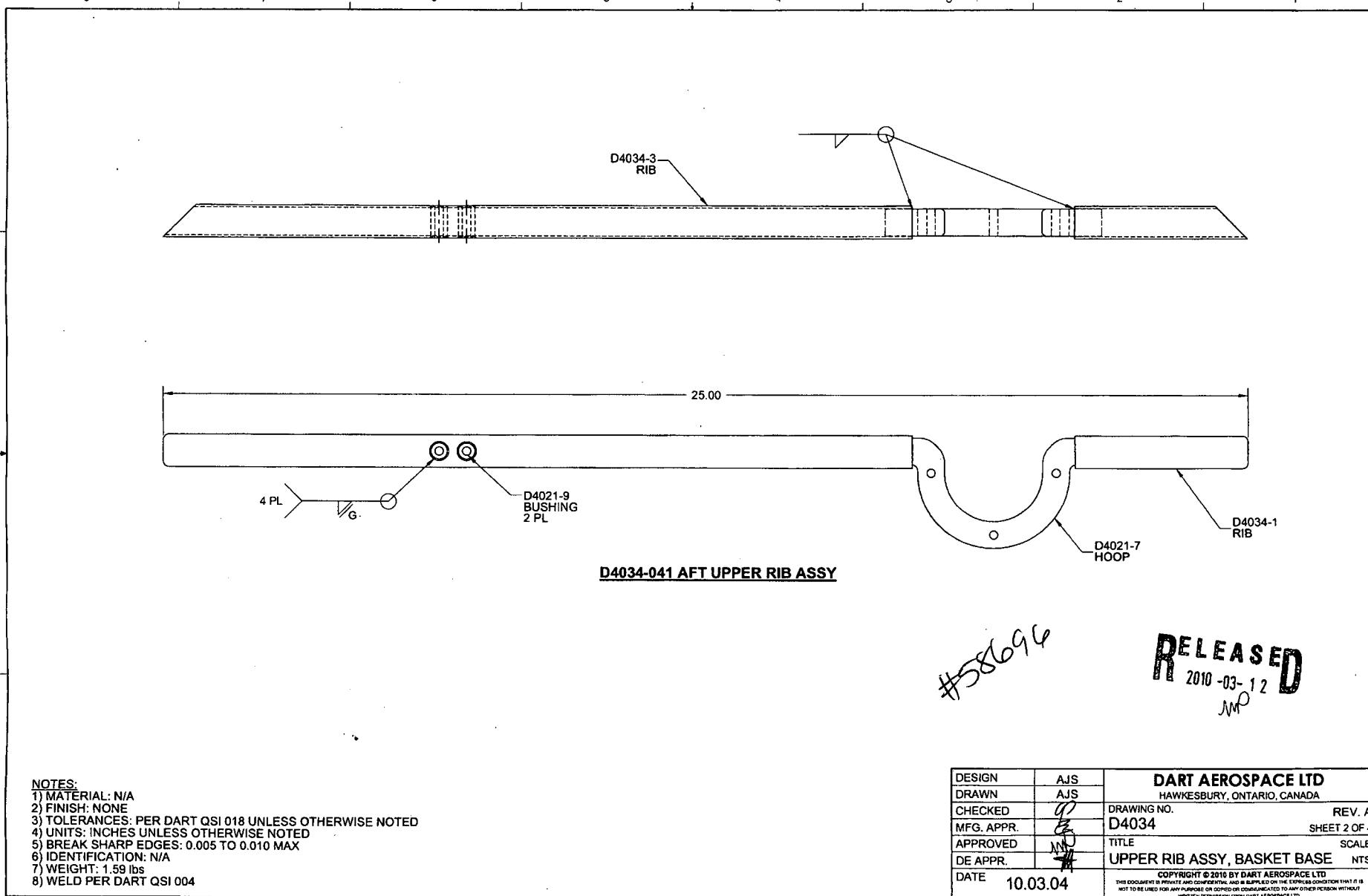
REV.	NEW ISSUE		AJS	10.03.04
			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	PP	DRAWING NO.	REV. A	
MFG. APPR.	EZ	D4034	SHEET 1 OF 4	
APPROVED	AM	TITLE	SCALE	
DE APPR.	AM	UPPER RIB ASSY, BASKET BASE	NTS	
DATE	10.03.04		COPRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE PROPERTY OF DART AND IS IMPERSONALLY OWNED. IT IS A CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED EXCEPT BY OTHER PERSONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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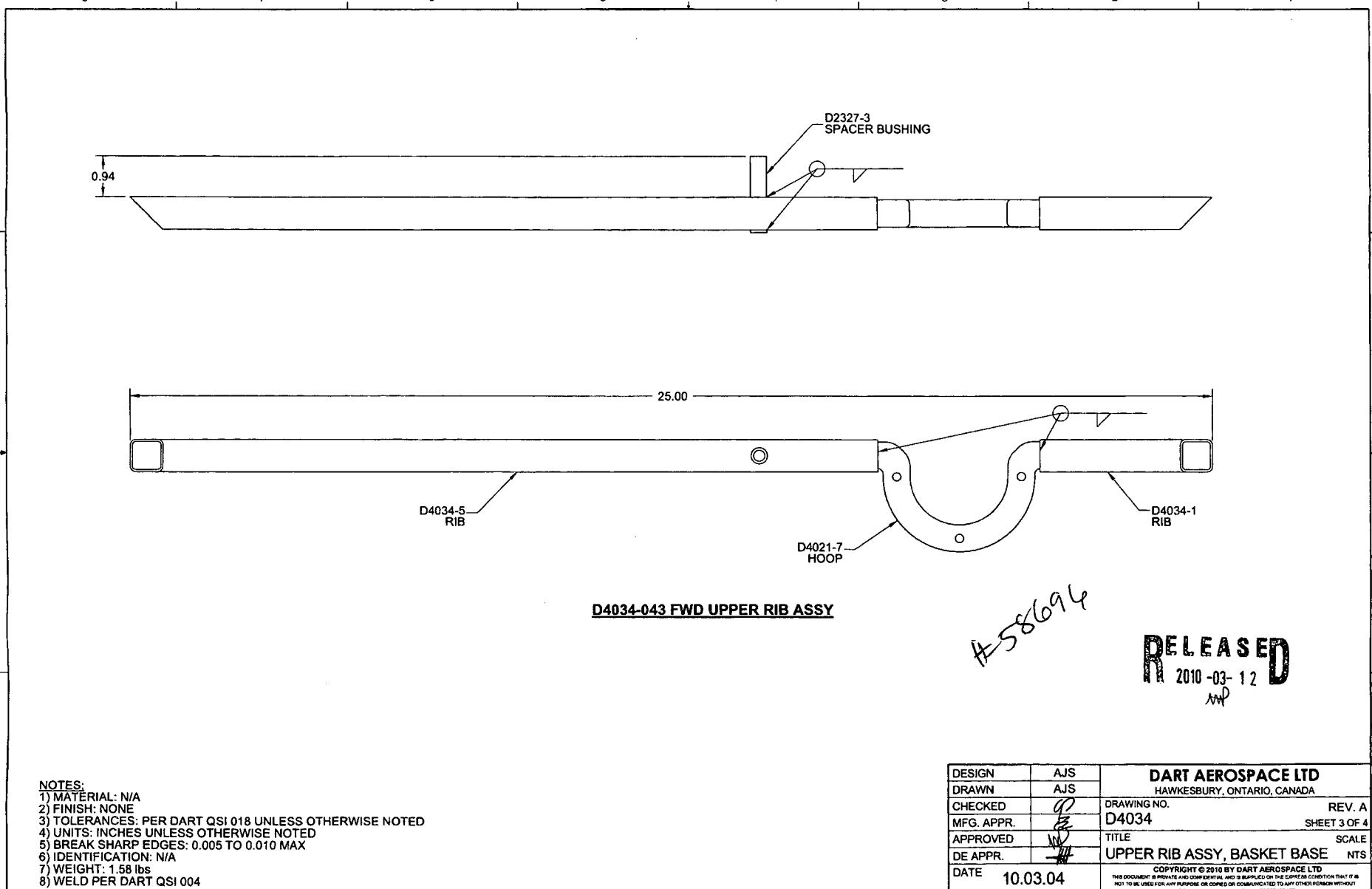
NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.59 lbs
 8) WELD PER DART QSI 004

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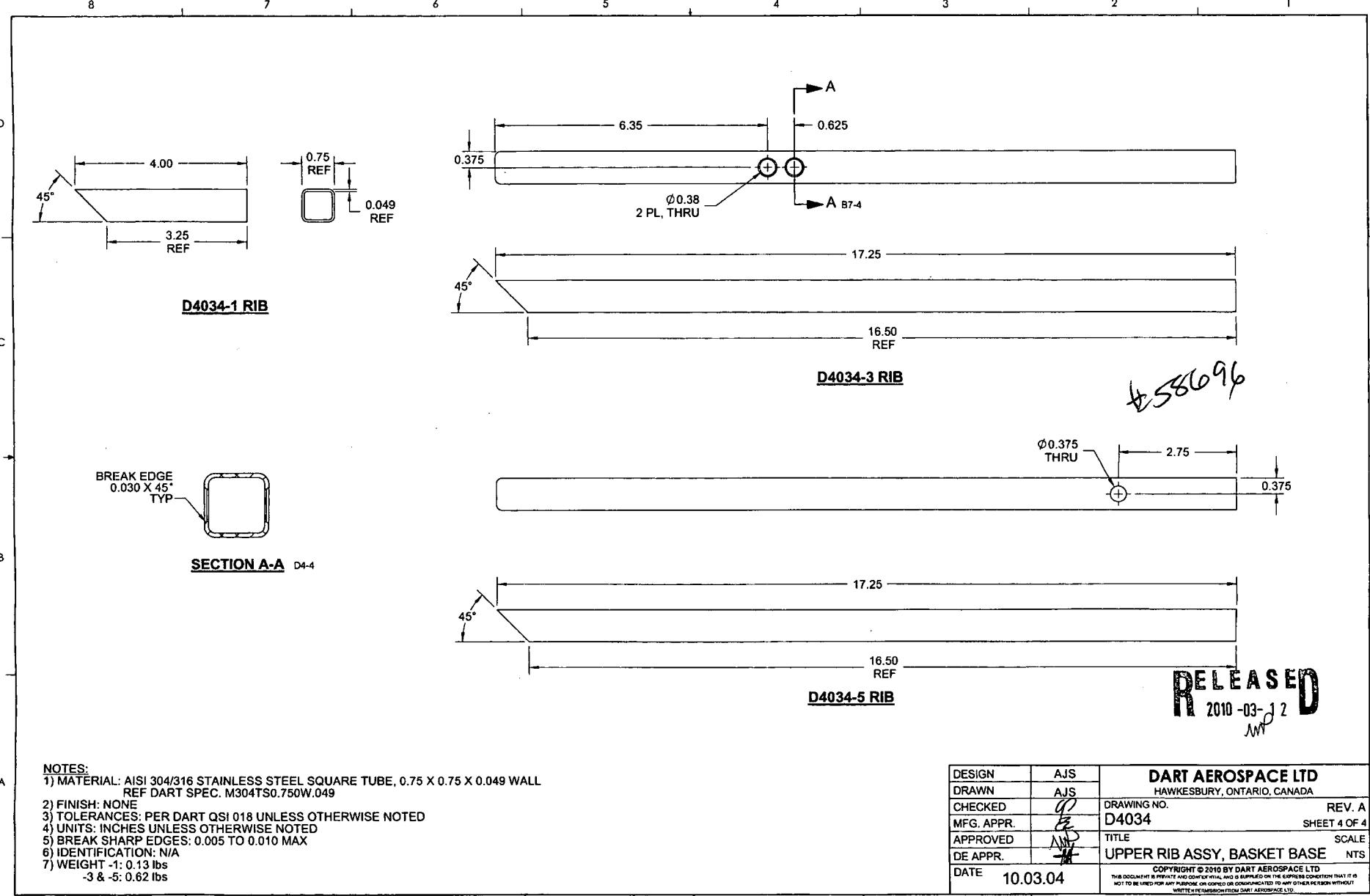


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